

# Work Order ID 50306



Page 1

July 14, 2009 11:50:39 AM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 7/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 100.00



Customer:

Reference: JMF09-07-17

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2230	Rev F

100 0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Band Saw Cut D2423 extrusion to 0.82" Batch: 45800

100

Ø

110



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio D2230-3 Check for crack while loading into the machine.

ML 09/08/17

101

Ø

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

ML 09/08/17

101

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 50306**

Page 2

July 14, 2009 11:50:39 AM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 7/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 100.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

130



QC

Quality Control

**Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

0.00

0.00

28/09/08/10

101

140



Small Fab

Small Fab

Small Fab

0.00

0.00

29/09/08/17

101

10

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

MO 09/08/18

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 50306**

Page 3

July 14, 2009 11:50:39 AM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 7/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 100.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

160



QC3- Inspect Part Finish

0.00

→ D 09/08/18

101

QC

Quality Control

170



White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

101

Powdercoat

Powder Coating

M112260

0.00

09-08-18 101 ✓

START TIME: 1:10 PM OVEN TEMPERATURE: 320°F

FINISH TIME: 1:40 PM

180



QC3- Inspect Part Finish

0.00

09-08-18 101 ✓

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50306



Page 4

July 14, 2009 11:50:39 AM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 7/27/09 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 09-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July 14, 2009 11:50:39 AM

Page 1

Work Order ID: 50306



Parent Item: D2230-3RevF



Parent Item Name: Lug

Start Date: 7/27/09

Required Date: 7/27/09

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3PRevF		Purchased		No		100	Each	0.0000	100.0000			
LUG												
D2423RevB1		Manufactured		No		100	f	767.4300	7.1895			

Lug Extrusion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	767.43	
43722	219.5	
44529	22.39	
45800	525.54	

*7/14/09/01*

*7f*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

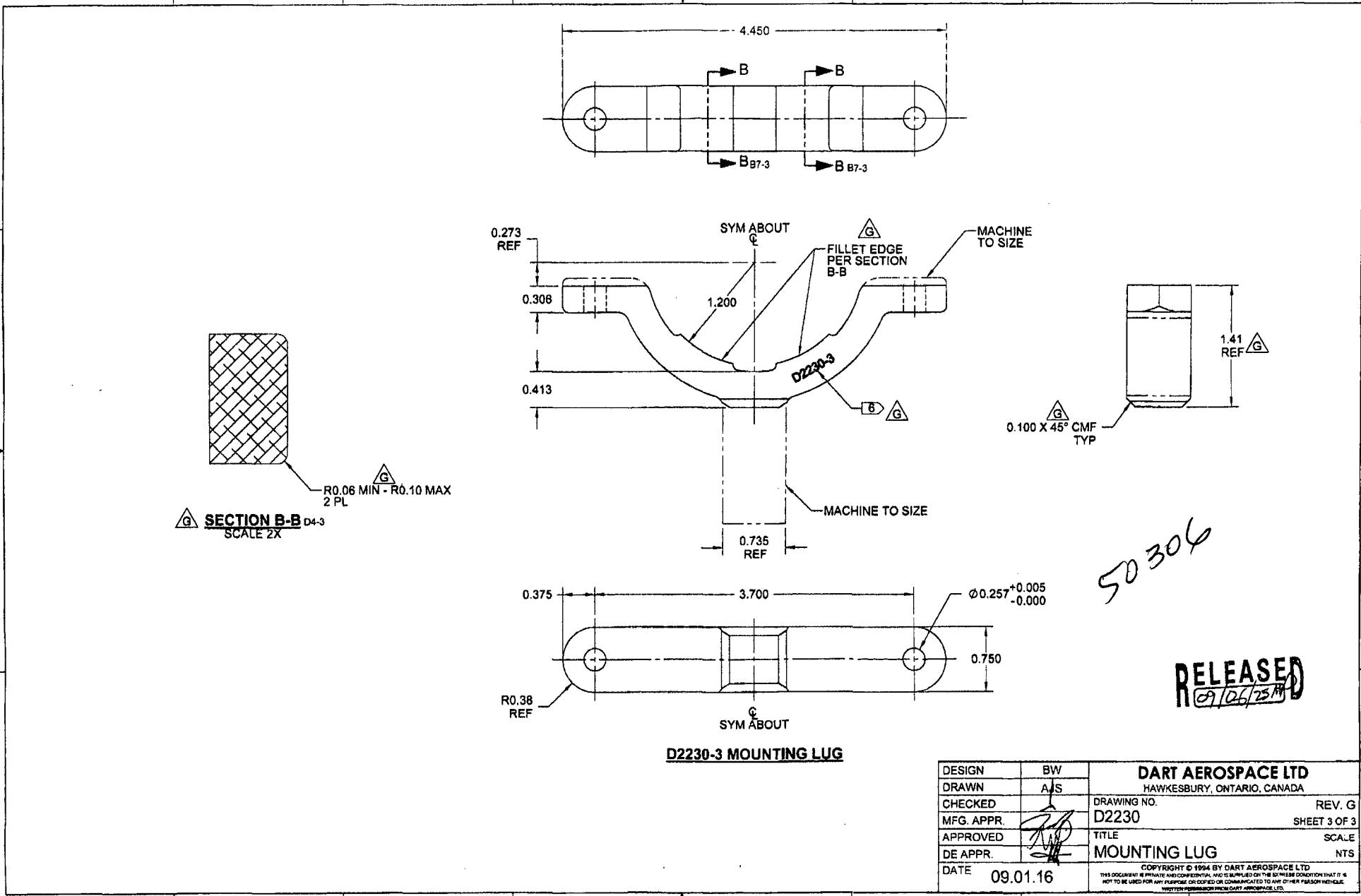
DART AEROSPACE LTD	Work Order:	50306
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230	Rev: F	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/08/17	Date:	09/05/28	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.11.11	New Issue	KJ/RF	PP



8 7 6 5 4 3 2 1

D

C

B

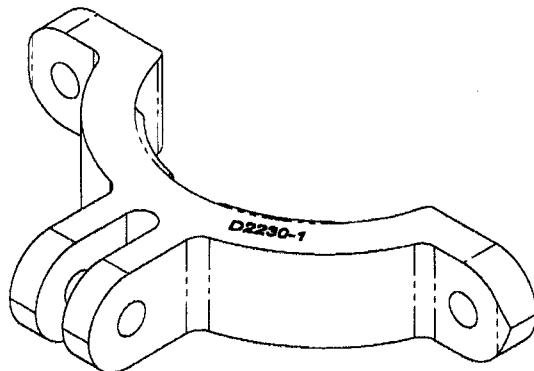
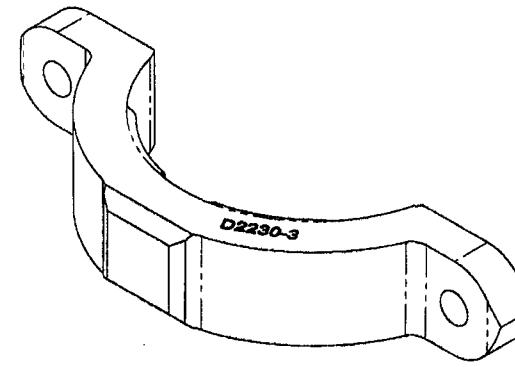
A

D

C

B

A

D2230-1 MOUNTING LUGD2230-3 MOUNTING LUG

SO 304

RELEASED  
09/06/2011

## NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION, WITH TOOL TIP RADIUS OF  $0.015 \pm 0.005$ .
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	09.12.13
E	RE-DESIGN	BW	09.01.04
D	RE-DESIGN	BW	09.01.04
C	RE-DESIGN	BW	04.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV: G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPRIGHT © 1994 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

